

Date:
User:Friday, 15/08/2008 11:03:31 AM
Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Job Number : 41256

Estimate Number : 13292

P.O. Number :

This Issue : 15/08/2008

S.O. No. :

Prsht Rev. : NC

First Issue : 11

Type : SMALL / MED FAB

Previous Run : 39033

Part Number : D37853

Drawing Number : D3785 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 15/08/2008

Qty POSITIVE
RECALL

2 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

Additional Product

Job Number:

PRELIMINARY ISSUE

~~PROTOTYPE~~

FOR ENGINEERING USE ONLY

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

0.125

6061-T6 .080 Sheet

Comment: Qty.: 0.2333 sf(s)/Unit Total: 0.4666 sf(s)

6061-T6 .080 Sheet

0.125

106634

IB 8-8-18

108433

IB 8-8-15

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PREL

Prog Rev: PREL

****grain direction along 3.60****

2- Deburr if necessary

IB 8-8-18

IB 8-8-15

IB 8-8-15

IB 8-8-18

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NC


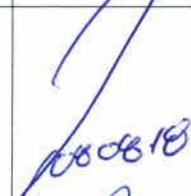
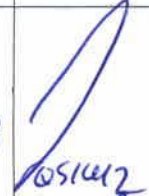

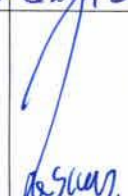
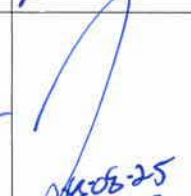



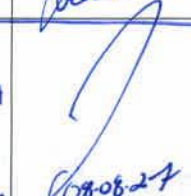
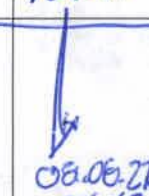
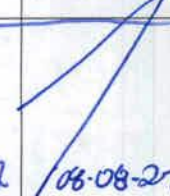
NC BRAKE

Comment: NC BRAKE

Bend as per Dwg D3785

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3785-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/02/17
 QA: N/C Closed: _____ Date: _____

NCR: <u>41256-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-15	1.0	0.080" thick material was used, as per estimate, not as per dwg (0.125")		Quarantine: identify. Replace Qty 3 as per dwg.	HB 8/8/12			
08/08/25	5	1 piece broke at the bend change radius 1/8 for 3/16		2x Scrap + destroy Dwg to be updated to change the radius.	SB 07/08/25			
08-08-26	7.0	Preliminary Issue HOLES NOT ALIGNING WITH D3781-1 R.C: 0.375" 0.375" hole location is no longer good due to the change in radius. See NC. S.O.		FILL WITH WELD HOLES MARKED ① & ②. DRILL + CSK HOLES AS SHOWN (NOTE: HOLES ARE 0.201 THRU, CSK 0.0395 x 100°)	Weld 08/08/27 08/08/27			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41256

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

108.08.25 ①

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3785

FF 08-08-25

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
REFERENCE ONLY
APPROVAL

ENGINEERING
APPROVAL

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/08/27 ①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M106442

①

START TIME:

7:20

OVEN TEMPERATURE:

320 °C

FINISH TIME:

7:50

M-L 08/08/28

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ENGINEERING
REFERENCE ONLY
APPROVAL

08-08-28

①

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

121

8/8/28

① SP

Date: Friday, 15/08/2008 11:03:32 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41256

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 *[Signature]*

Job Completion



U 09-02-18

POSITIVE RECALL

EFFECTIVE

05.08.20

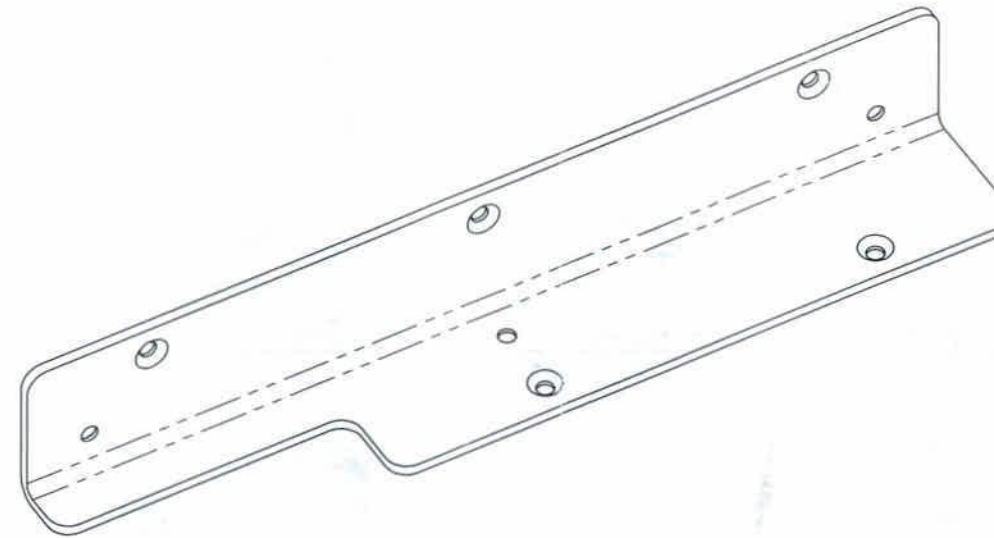
AUTH

U

RELEASED

DATE

09.02.17



D3785-3 BRACKET

PRELIMINARY ISSUE

08.08.19

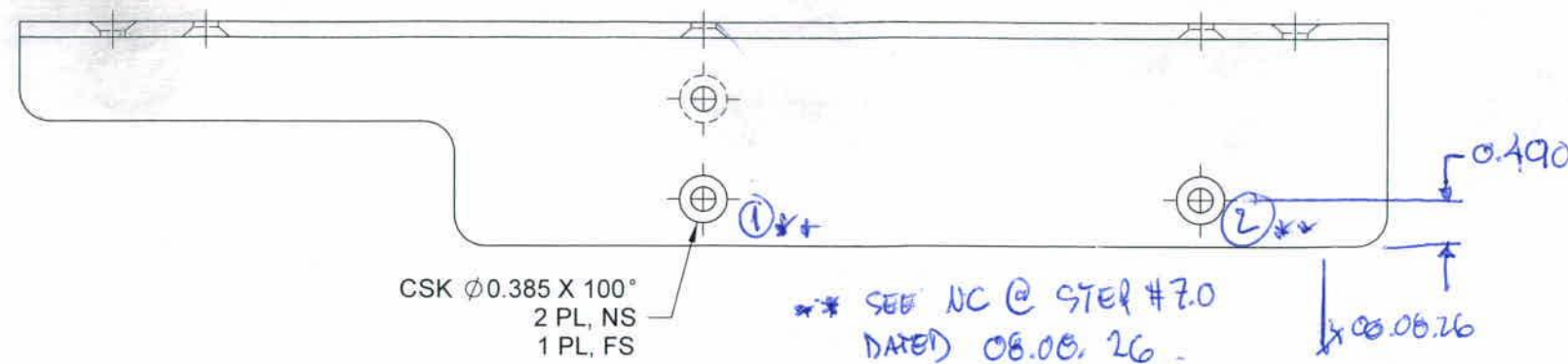
MD
41250

NOTES:

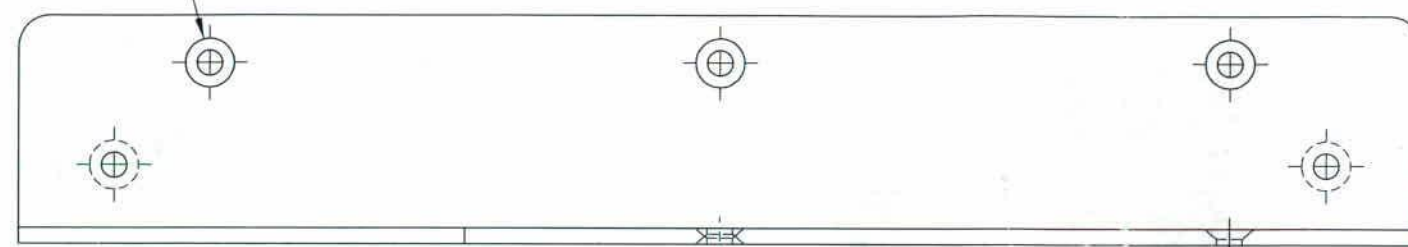
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.41 lbs



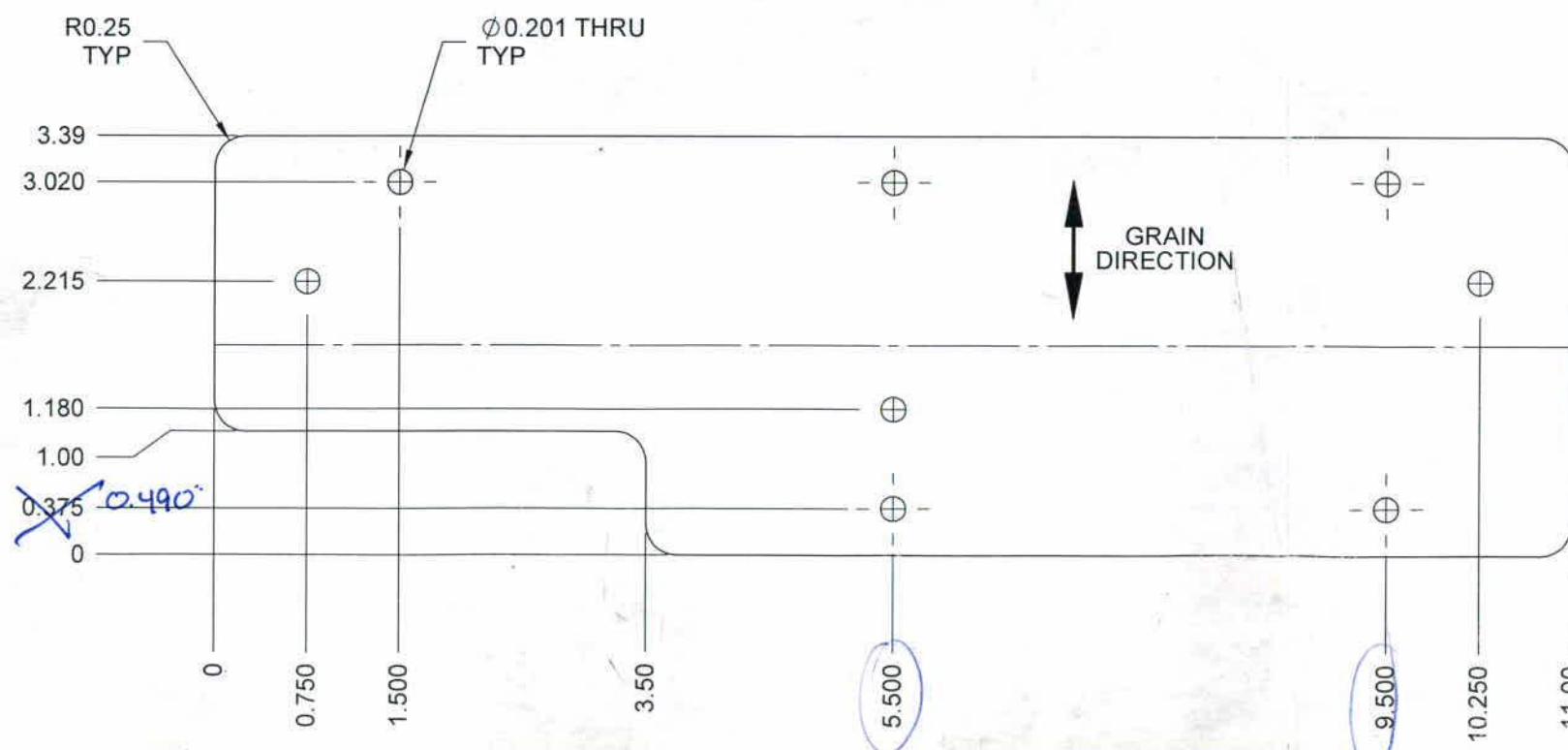
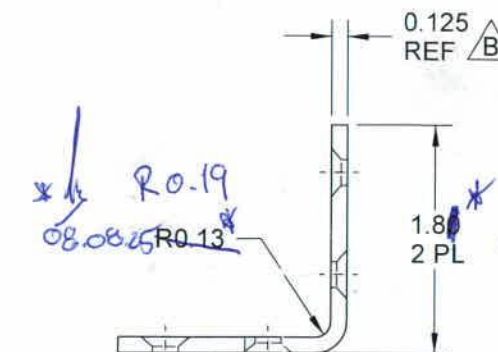
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; MATERIAL THICKNESS WAS 0.080 (ZN A6-1 AND C2-2); DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3785	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	08.07.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



CSK $\phi 0.385 \times 100^\circ$
3 PL, NS
2 PL, FS



D3785-3 BRACKET
MAKE FROM D3785-3F



D3785-3F FLAT PATTERN

PRELIMINARY ISSUE

08.08.15

41256

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3785	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	08.07.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DEFINITION

Date: Friday, 15/08/2008 11:03:31 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 41256		
Estimate Number	: 13292		
P.O. Number	:	Part Number	: D37853
This Issue	: 15/08/2008 S.O. No. :	Drawing Number	: D3785 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: PRELIM
Previous Run	: 39033	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>MVF 08-08-15</u>		
Comment	: Est Rev:A 08-05-01 new issue DD verified by:EC		

Additional Product

PROTOTYPE

Job Number:

FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080 -125	6061-T6 .080 Sheet
-----	------------------	--------------------

Comment: Qty.: 0.2333 sf(s)/Unit Total: 0.4666 sf(s)
 6061-T6 .080 Sheet

HB 8-8-18

HB 8-8-15

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PREL

Prog Rev: PREL

****grain direction along 3.60****

2- Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

Comment: NC BRAKE

Bend as per Dwg D3785

Receiving Report

Date: 7/12/19
 Supplier: MAGNA

Batch No: 1106634
 Dart P/O: 5288

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☐ No ☐ N/A ☒
 Q/C6 Inspection 4/12/21 N/A ☒
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin:

Date

Received/Costing

Initial

07/12/21
REP 6574
CS

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total
 G.S.T.

691.00
 41.46

TOTAL →

732.46

RAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
 AYANT PRIIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

DOC : V/00801234

DATE : 2008-07-14

PROD. REF. : 0000182192/006

URGES : 65698/04

PAGE : 1/ 2

INSPECTION CERTIFICATE

COPIED FROM : CORUS ALUMINIUM ROLLED PRODUCTS US

YOUR ORDER NUMBER : 604617-2

DOC ORDER NUMBER : V/00801234

ALU SHEETS (STICK) 500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

500 X 1000 X 1.50

CORUS ALUMINIUM ROLLED PRODUCTS - CORUS ALUMINIUM EXTRUSIONS

CORUS ALUMINIUM

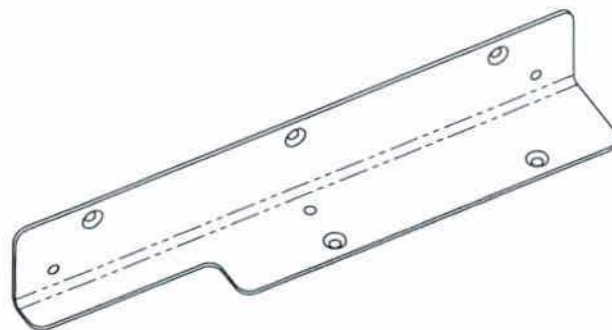
0002/04/20

0003

6/14/09

5/14/09

CB-699



D3785-3 BRACKET

41256

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

RELEASED
09/06/18

B	REDESIGNED D3785-3; REMOVED P/Ns D3785-0411-11-51-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3785
REV. B
SHEET 1 OF 2

TITLE
BRACKET
SCALE
NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PREPARED AND CONTAINED HEREIN IS SUPPLIED ON THE CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

